

Work Order ID 72899

Wednesday, August 17, 2011 2:47:23 PM



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[Handwritten signature]

Work Order ID 72899

Wednesday, August 17, 2011 2:47:23 PM



Page 1

Item ID: D4273-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11-08-17

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4273

D

D4279

B

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N- N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

Pl 11-08-23

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

--	--	--	--	--	--	--	--

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Setup Start

Revision ID:

Stop

Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

GA
73262UHF
11-08-31

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/31

UHF
11-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 72899

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC
 11.01.20 AS PER DWG REV.C DD verf:EC
 AS PER DWG REV.D DD verf:EC
 IPP Rev:B
 IPP Rev:C 11.03.03

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

972.3487

26.195

26.195



Expanded Metal Flat SS



6/11.08.25

Location

Loc Qty

Loc Code

MAT

11.5607

117708

11.5607

WA

960.788

115012

95

117197

102.9036

117455

16.0341

117896

53.3264

118153

98.6394

118248

33.0983

118450

241.7862

118597

320

26.195

D3913-1

Manufactured

No

100

Each

7.0000



Rib



6/11.08.22

Location

Loc Qty

Loc Code

WA

7

59089

1

69260

2

70346

2

72086

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 72899

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each

7.0000

1



Rib



1
Pl 11.08.22

Location Loc Qty Loc Code

WA	4	
69160	1	
72664	3	
WA006	3	
69646	2	
71482	1	

D3913-9 Manufactured No

100 Each

7.0000

1



Hinge Rib



1
Pl 11.08.22

Location Loc Qty Loc Code

WA	4	
70336	1	
72665	3	
WA006	3	
70138	1	
71479	2	

D3916-5 Manufactured No

100 Each

20.0000

3



Light Rib



3
Pl 11.08.22

Location Loc Qty Loc Code

WA	11	
59088	3	
71938	8	
WA006	9	
72557	9	

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 72899

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7 Manufactured No

100 Each

6.0000

1

1



Rib



Pl 11.08.22

Location

Loc Qty

Loc Code

WA

4

69730

1

72556

3

WA005

2

72008

2

D4277-3 Manufactured No

100 Each

1.0000

1

1



Rib



Pl 11.08.22

Location

Loc Qty

Loc Code

WA

1

71734

1

D4277-5 Manufactured No

100 Each

0.0000

2

2



Rib



372903 -> ② Pl 11.08.23

D4277-9 Manufactured No

100 Each

1.0000

1

1



Rib



Pl 11.08.22

Location

Loc Qty

Loc Code

WA

1

71731

1

D4277-19 Manufactured No

100 Each

0.0000

1

1



Rib



372910 -> ① Pl 11.08.23

D4278-041 Manufactured No

100 Each

0.0000

1

1



Upper Rib Assembly-Hoop



372908 -> ① Pl 11.08.23

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Shop Packet Print

Page 3

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Work Order ID: 72899

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4278-045 Manufactured No

100 Each

0.0000

2 2



Rib Assembly, Fwd Cham

D4278-047 Manufactured No

100 Each

0.0000

1 1



Upper Rib Assembly-Straight

D4306-1 Manufactured No

100 Each

1.0000

1 1



Rib

Location

Loc Qty

Loc Code

WA

71737

1

1

D4306-044 Manufactured No

100 Each

0.0000

1 1



Rib Assembly, RH

D4306-045 Manufactured No

100 Each

0.0000

1 1



Rib Assembly

D2581 Manufactured No

100 Each

41.0000

2 2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

69258

69739

70766

41

28

2

11

①

372944 → ① Pl 11.08.22

372901 → ① Pl 11.08.22

Pl 11.08.22

②

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Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-15

Manufactured No

100 Each

10.0000

1

1



Wide Handle Plate



Pl 11.08.22

Location

Loc Qty

Loc Code

WA

3

69647

3

WA005

7

69012

1

72550

6

D4016-1

Manufactured No

100 Each

22.0000

3

3



Hinge Half, Base



Pl 11.08.22

Location

Loc Qty

Loc Code

WA

22

66418

0

68426

3

70342

1

72009

18

D4021-1

Manufactured No

100 Each

24.0000

3

3



Handle Plate



Pl 11.08.22

Location

Loc Qty

Loc Code

WA

24

69518

6

69777

18

D4279-3

Manufactured No

100 Each

0.0000

1

1



Mesh, Chamfer



372907 -> ① Pl 11.08.25

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Page 5

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72899

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4279-5 Manufactured No

100 Each

1.0000

1 1



End Mesh, Basket



PMB 11/08/30

Location

Loc Qty

Loc Code

WA

1

68051

1

D4279-7 Manufactured No

100 Each

0.0000

2 2



End Mesh, Basket



B72909 → ② 11-08-29

D4279-9 Manufactured No

100 Each

1.0000

1 1



End Mesh, Basket



11-08-30

Location

Loc Qty

Loc Code

WA

1

63790

1

D4279-11 Manufactured No

100 Each

0.0000

1 1



Mesh, Base



B72911 → ① 11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

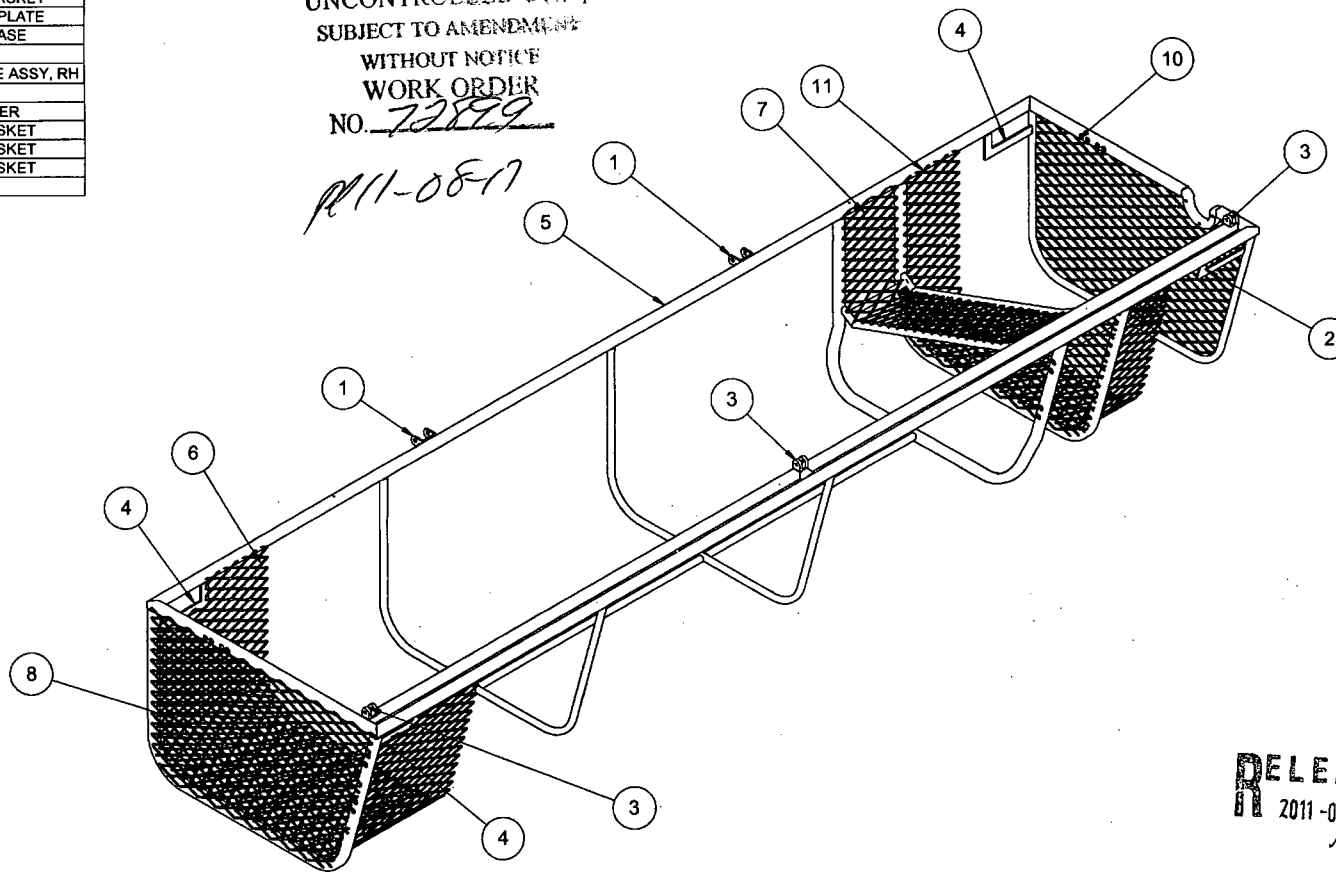
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -042	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE





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RETURN TO:
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72899
R11-0817



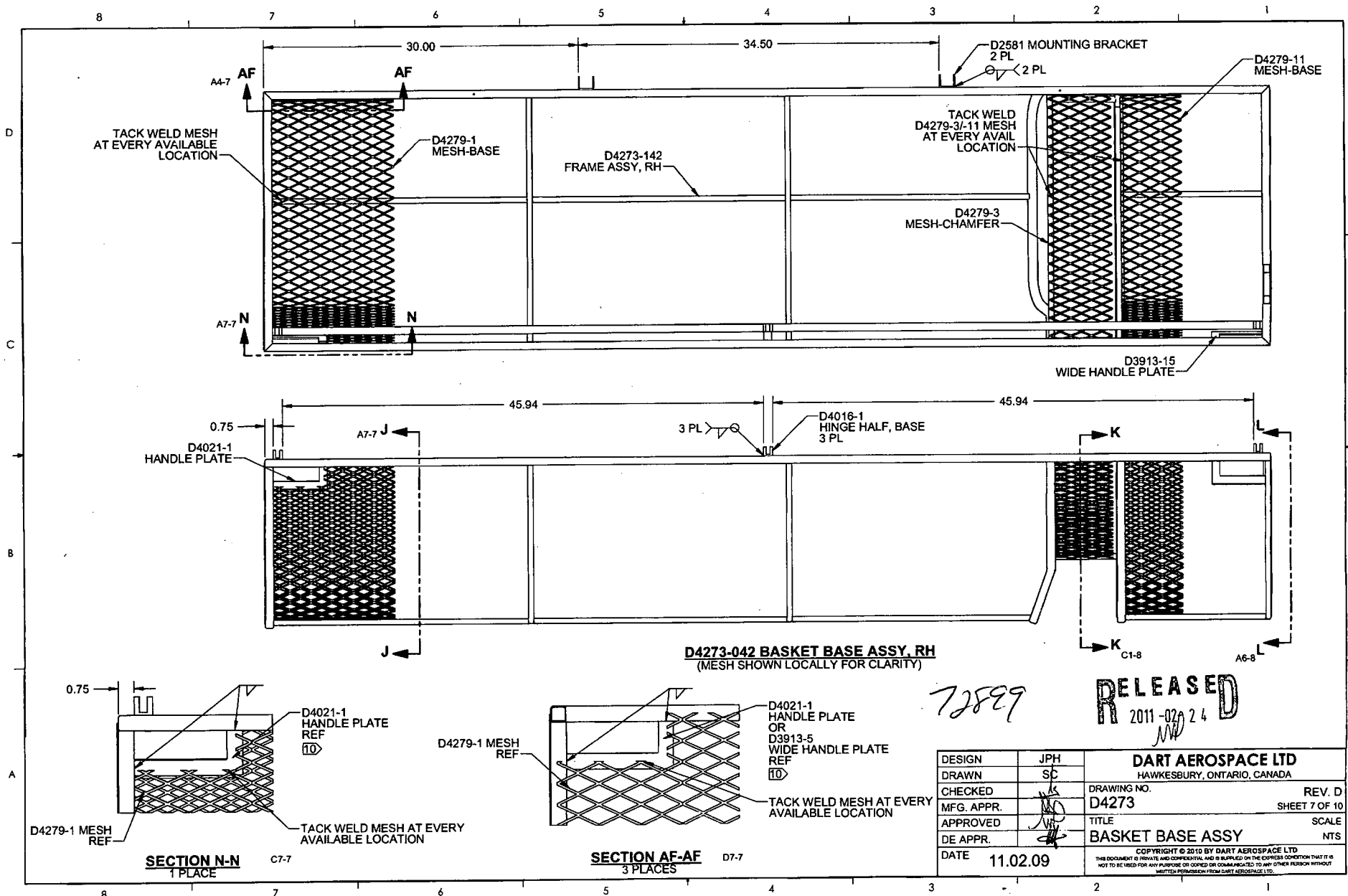
D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)




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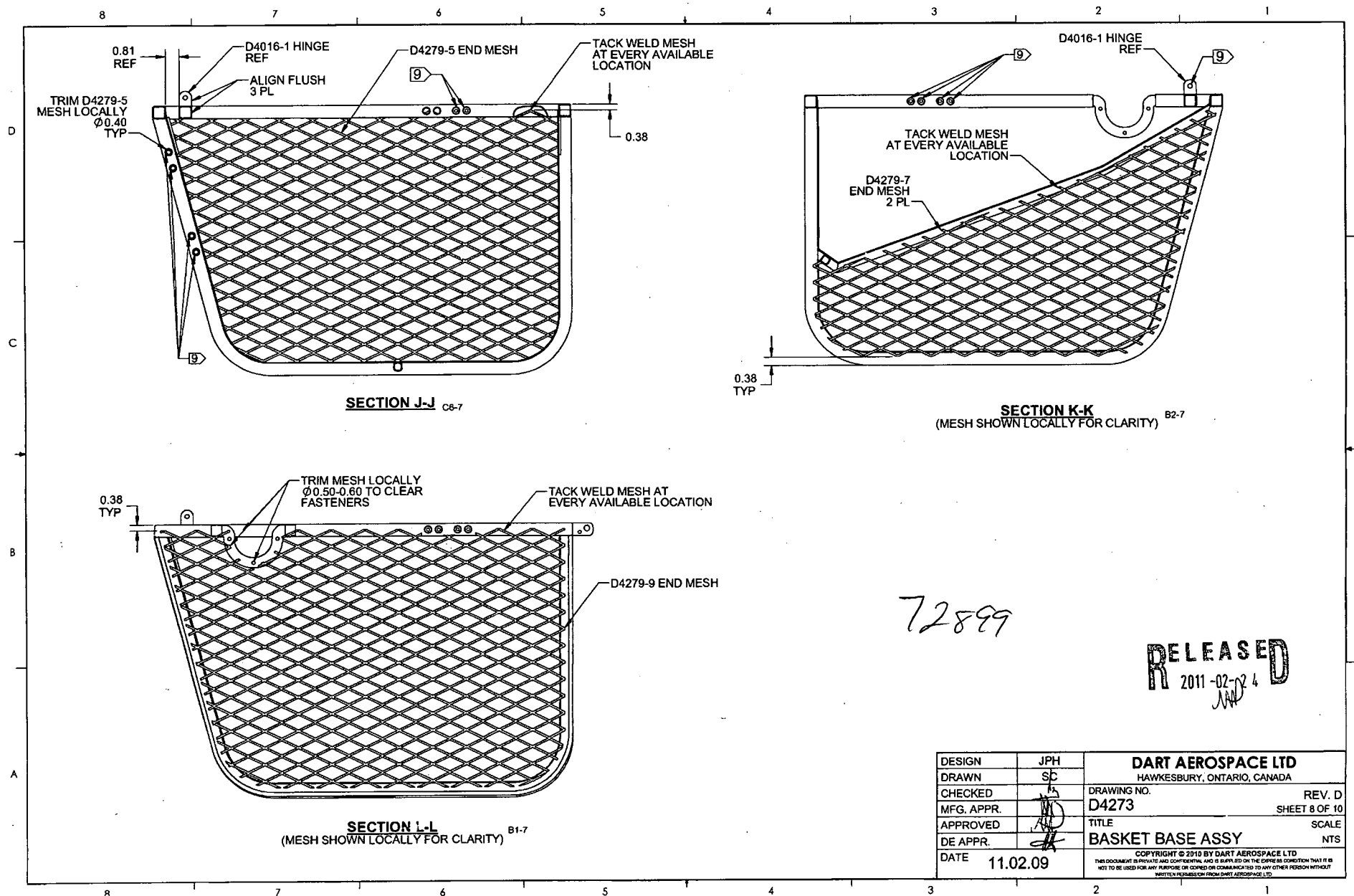
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 6 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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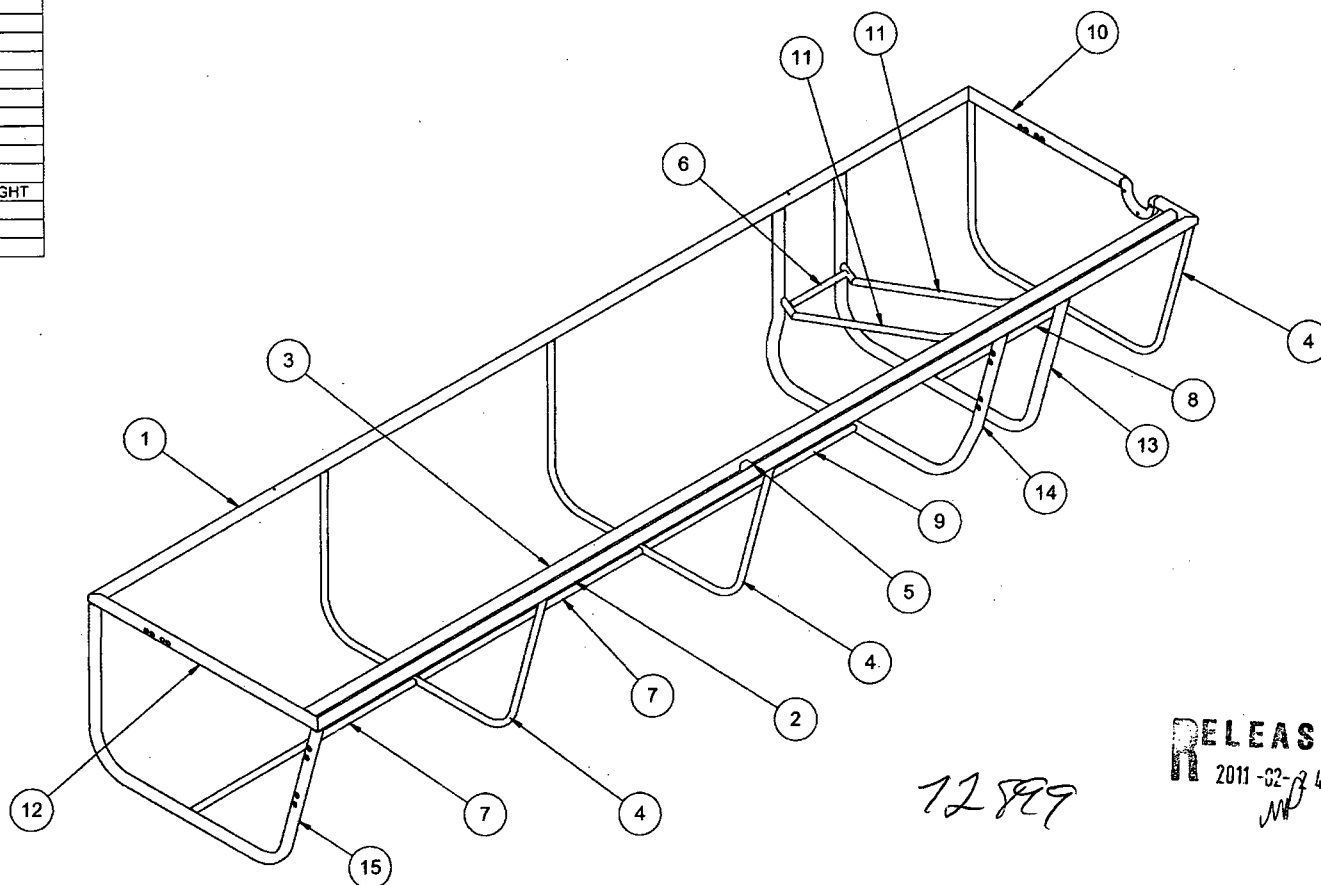
RELEASED
R 2011-02-24
[Signature]



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 7 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY

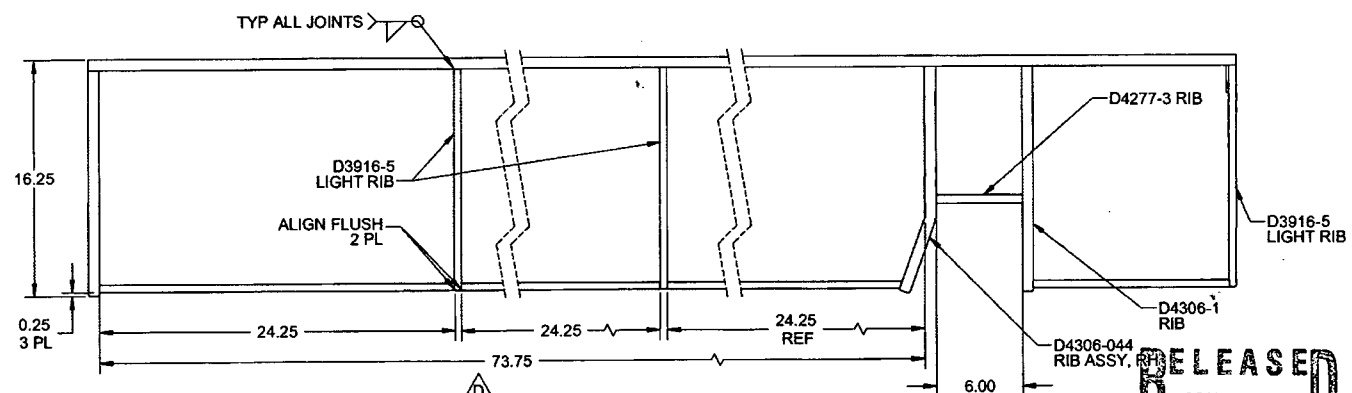
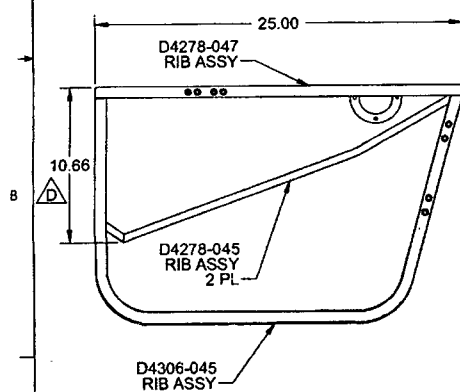
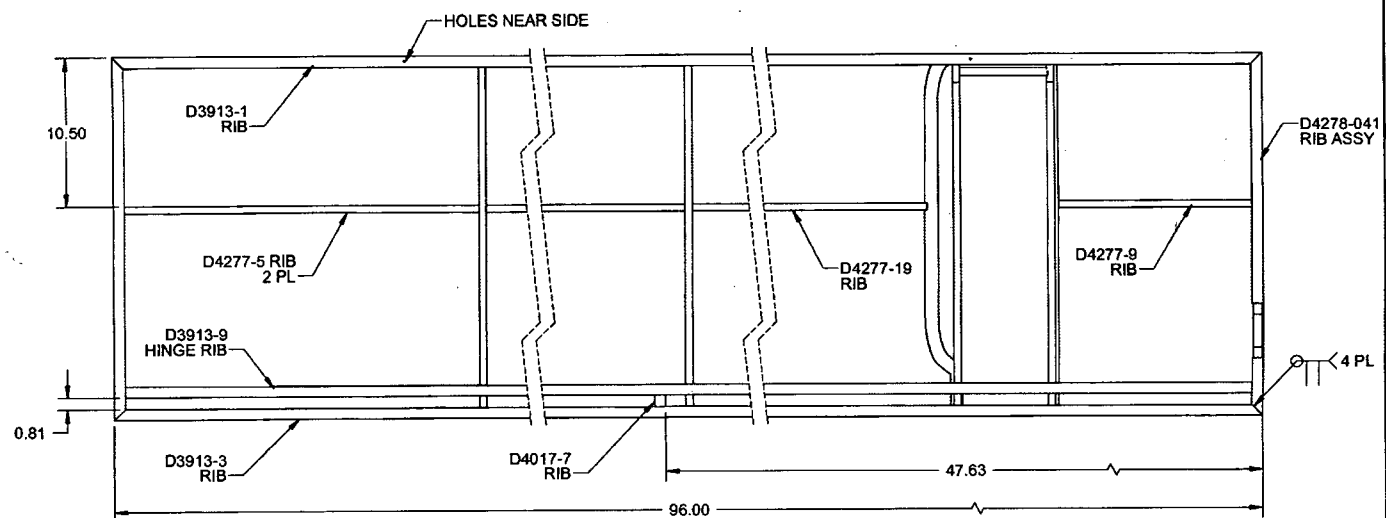


D4273-142 BASKET FRAME ASSY, RH

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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RELEASED
2011-02-04
MB

12899



D4273-142 BASKET FRAME ASSY. RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.77 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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R 2011-02-24

72899